

Work Order ID 69601

Thursday, May 12, 2011 3:31:56 PM



Page 1

Item ID: D3290-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 5/12/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-15-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3290

DEO Rev C1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 (use prog. for D3290-1)

Dwg Rev: C1

Prog Rev: C1

2-Deburr if necessary

B11-5-17



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S110518



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 12:40

OVEN TEMPERATURE: 320°

FINISH TIME: 11:10

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8 0 11-5-18 810

8 0 11-5-19

8 0 11-5-19

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16/05/11	130							

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Work Order ID 69601

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Item ID: D3290-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 5/12/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/06

ME
11-07-06

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 12, 2011 3:32:04 PM

Page 1

Work Order ID: 69601



Parent Item: D3290-041



Parent Item Name: Replacement Window Assembly

Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B 05.05.25 Added Step 11 KJ/JLM
IPP C 06.05.09 Ecn 798 EC
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	320.5000	3.75	31.57895	30	11/14-5-17	

Location	Loc Qty	Loc Code
MAT021	320.5	
116308	32.5	
117285	288	

D2126 Seal		Manufactured	No			160	f	564.2586	6.5	52			
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Location	Loc Qty	Loc Code
ST405	564.2586	
57106	4	
64918	60.2586	
68336	500	

(D2126-0780) cut qty (1) at 78.00" as per dwg
per kit

D3290-3 Window		Manufactured	No			160	Each	0.0000	1	8			
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B.69556

x 8

11/07/05

11/07/05

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Dart Aerospace Ltd

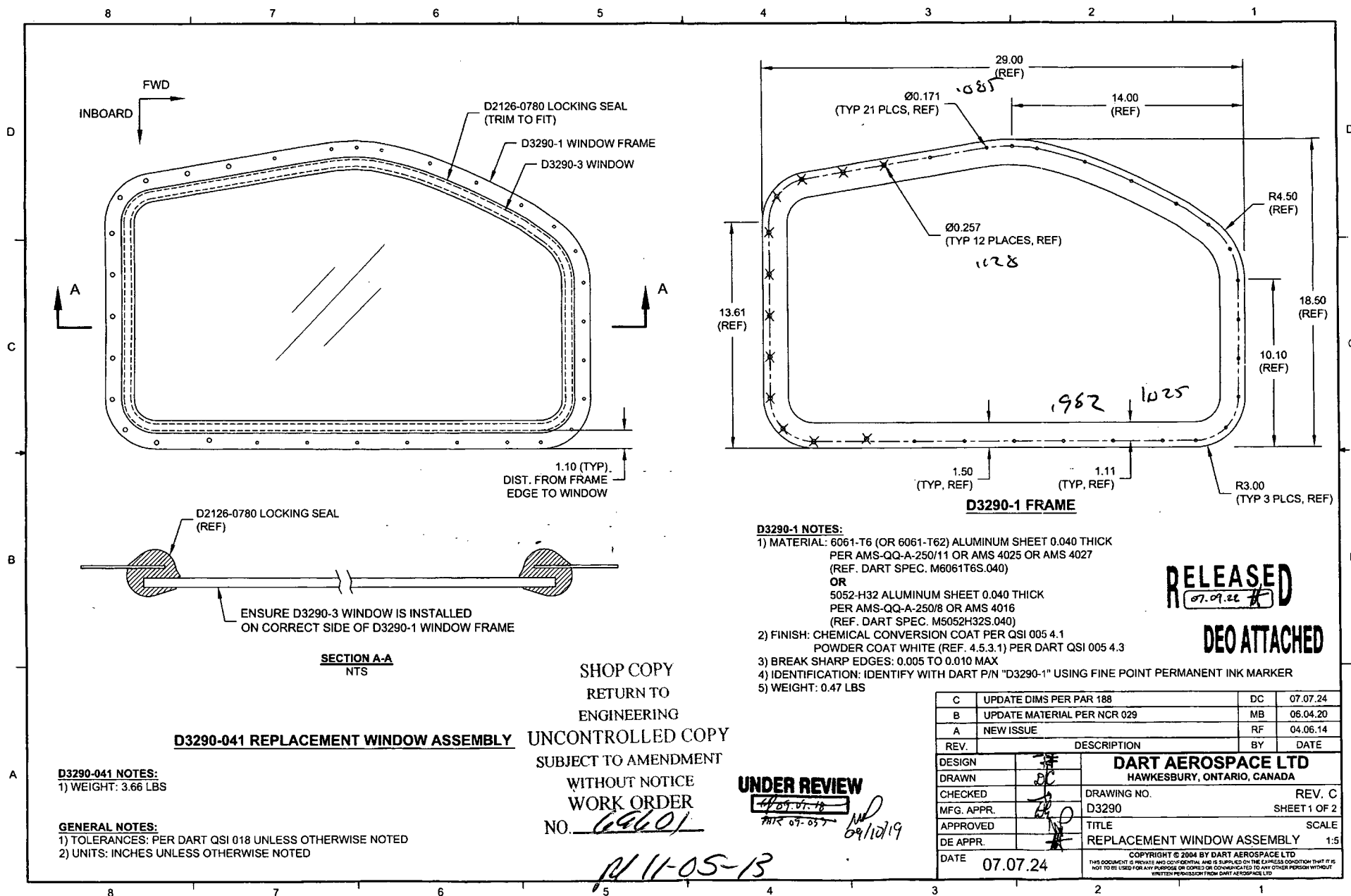
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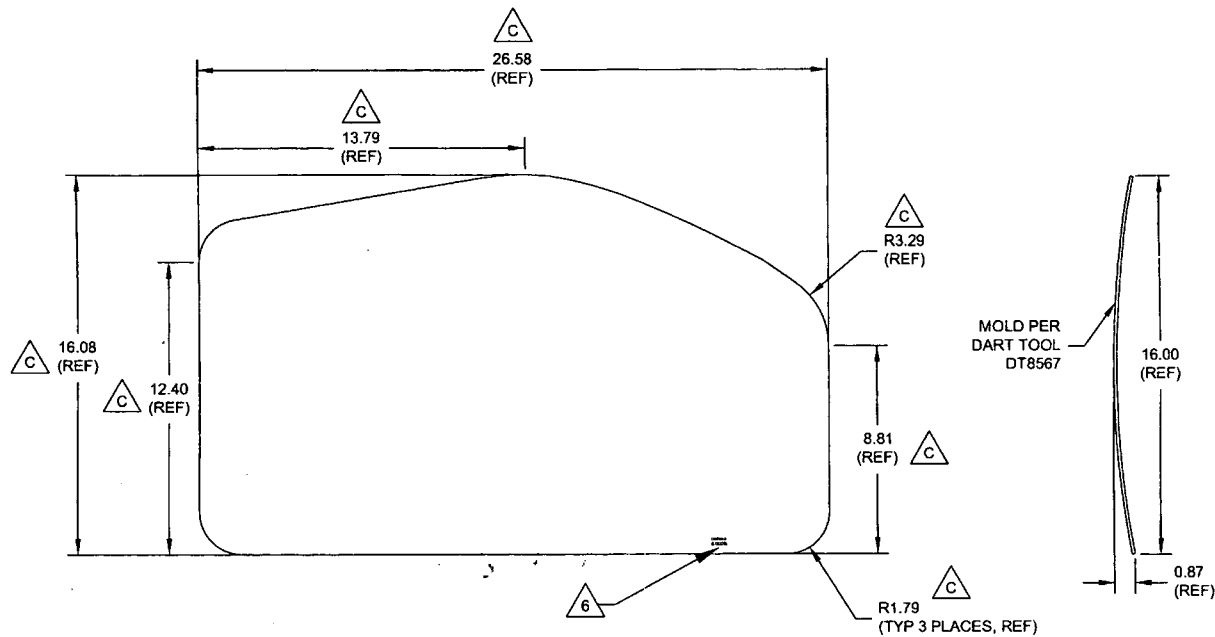
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D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED

RELEASED

W069601

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	

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Dart Aerospace Ltd

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>js</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09

u1069601

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